

Work Order ID 85870

June-18-12 10:51:38 AM

85870

Page 1

Item ID: D3536-39

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket

Start Date: 15/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/18* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3536	Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 Dwg Rev: *A* Prog Rev: *1A* 2-
Deburr if necessary

neo 1063

1617 0 Jm 12-6-19

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1617 0 Jm 12-6-19

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/2/20

(47)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Required Date: 02/07/2012 Req'd Qty: 10.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: **FB**

0.00

130

Packaging

Memo

0.00

Packaging

17

12/06/2012

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/6/2012

MCJ 12/06/20

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NOTE: Date & initial all entries

Picklist Print

June-18-12 10:51:43 AM

Page 1

Work Order ID: 85870

85870

Parent Item: D3536-39

D3536-39

Parent Item Name: Gasket

Start Date: 15/06/2012

Required Date: 02/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MNEO60S.063

Purchased

No

100

sf

16.7729

0.7534

8.371111

**

MNEO60S 063

NEOPRENE SHEET 0.063

Jm 12-6-19

Location

Loc Qty

Loc Code

MAT052

16.772884

120948

16.772884

122112

122112

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DART AEROSPACE LTD		Work Order:	85870
Description: Gasket		Part Number:	D3536-39
Inspection Dwg: D3536	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
35.71	+/-0.030	35.71"	✓		MT	W301
32.78	+/-0.030	32.78"	✓		MT	"
29.28	+/-0.030	29.28"	✓		MT	"
25.78	+/-0.030	25.78"	✓		MT	"
23.25	+/-0.030	23.25"	✓		MT	"
19.75	+/-0.030	19.75"	✓		MT	"
17.75	+/-0.030	17.75"	✓		MT	"
14.25	+/-0.030	14.25"	✓		MT	"
9.50	+/-0.030	9.50"	✓		✓	Producer
4.75	+/-0.030	4.75"	✓		✓	mmol
5.00	+/-0.030	5.00"	✓		✓	"
9.00	+/-0.030	9.00"	✓		✓	Producer
0.30	+/-0.030	0.30"	✓		✓	mmol
0.30	+/-0.030	0.30"	✓		✓	"
1.88	+/-0.030	1.88"	✓		✓	"
Ø0.19	+0.005/-0.001	0.19"	✓		✓	"
0.063	+/-0.010	0.062"	✓		✓	"

Measured by: JM	Audited by: S	Prototype Approval:	N/A
Date: 12-6-19	Date: 12/06/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	[Signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

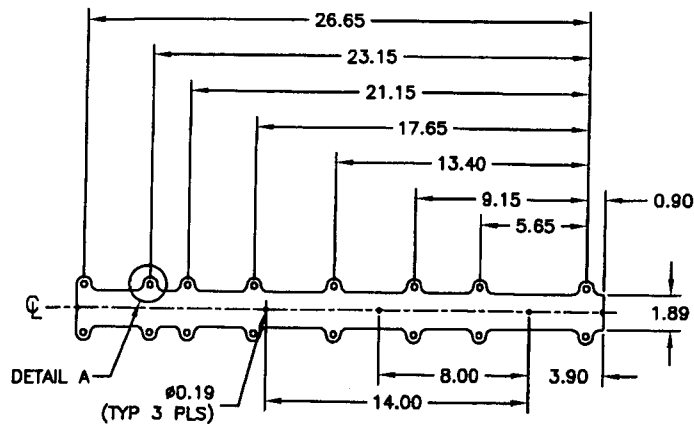
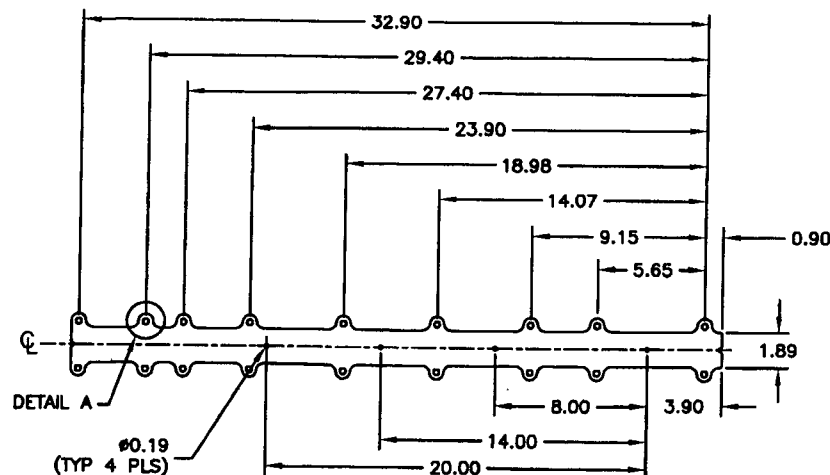
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTRELEASED
09.02.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25870 MW
12/06/18

**D3536-11 GASKET****D3536-13 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART Aerospace USA, Inc.	
CB	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
MH	MH	D3536	SHEET 1 OF 6
DATE	TITLE	SCALE	
06.10.25	GASKET	1:10	
A	06.10.25	NEW ISSUE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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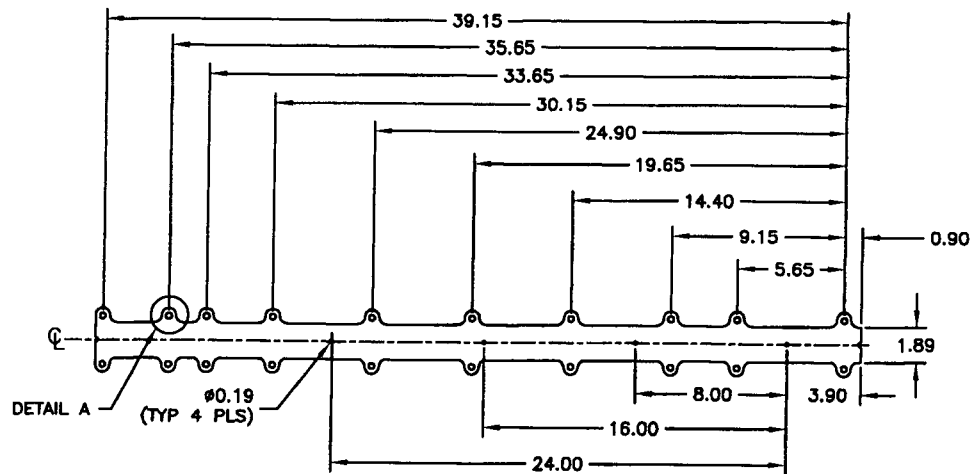
NOTE: Date & initial all entries

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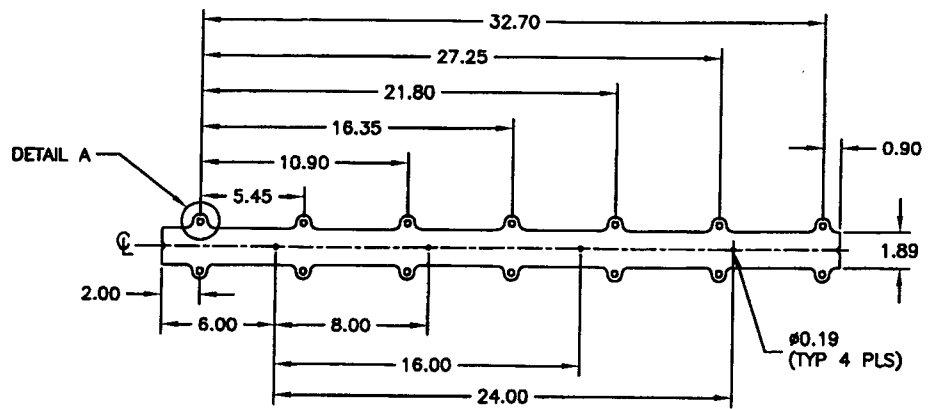


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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 2 OF 6
		SCALE	1:10	



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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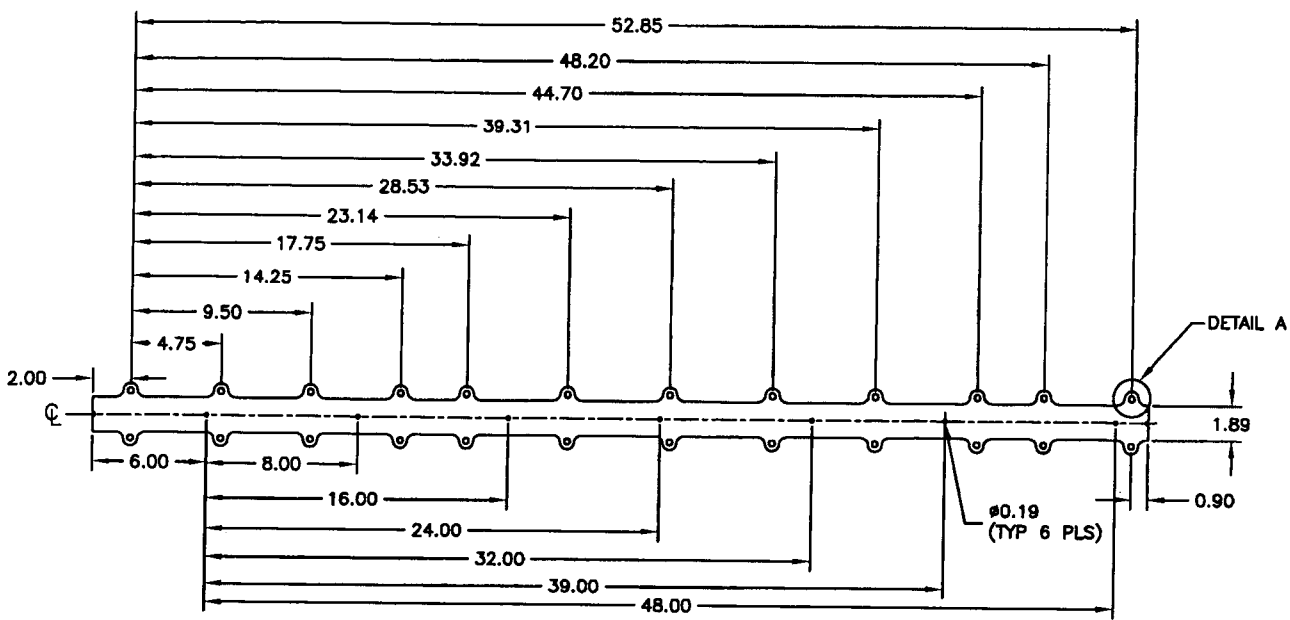
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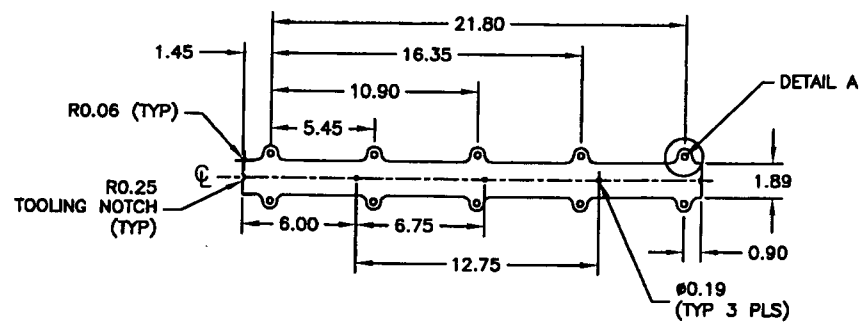
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DART

07.02.12
#



D3536-23 GASKET



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 3 OF 6
		SCALE	1:10	

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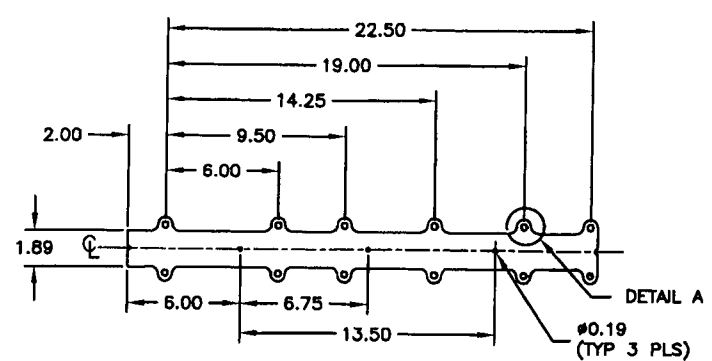
NOTE: Date & initial all entries

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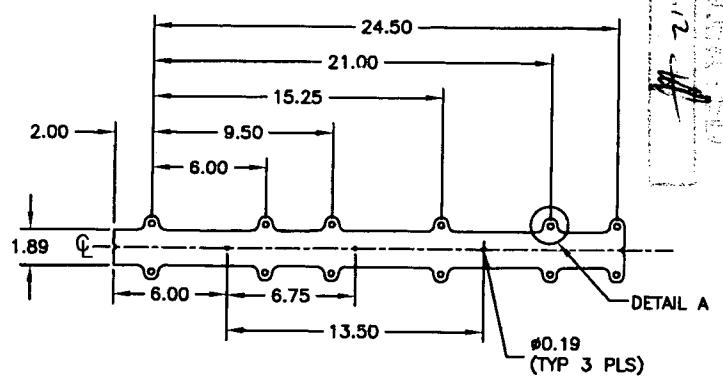


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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 4 OF 6
		SCALE	1:10	

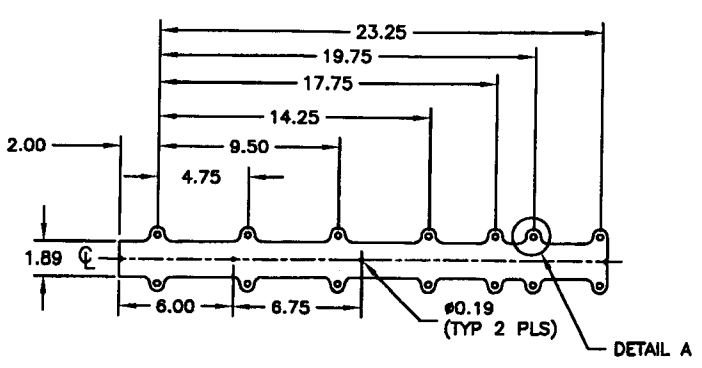
07.02.12



D3536-31 GASKET



D3536-33 GASKET



D3536-35 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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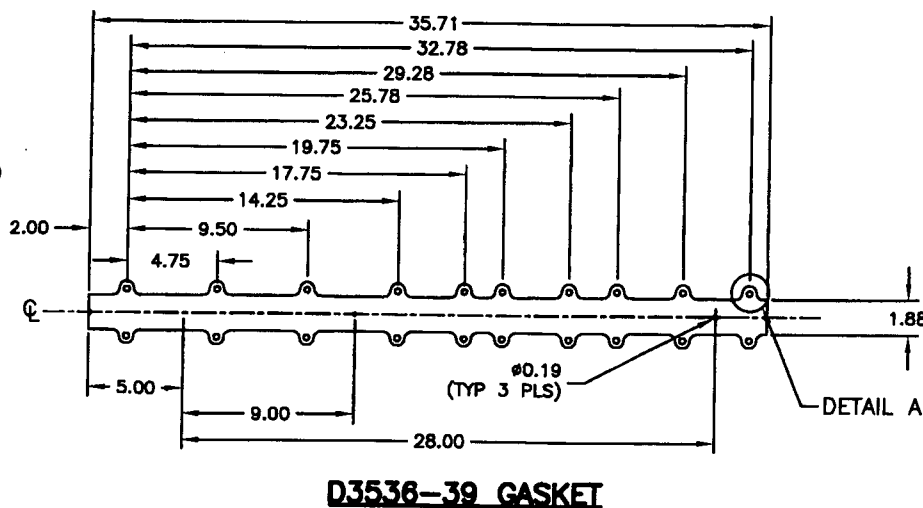
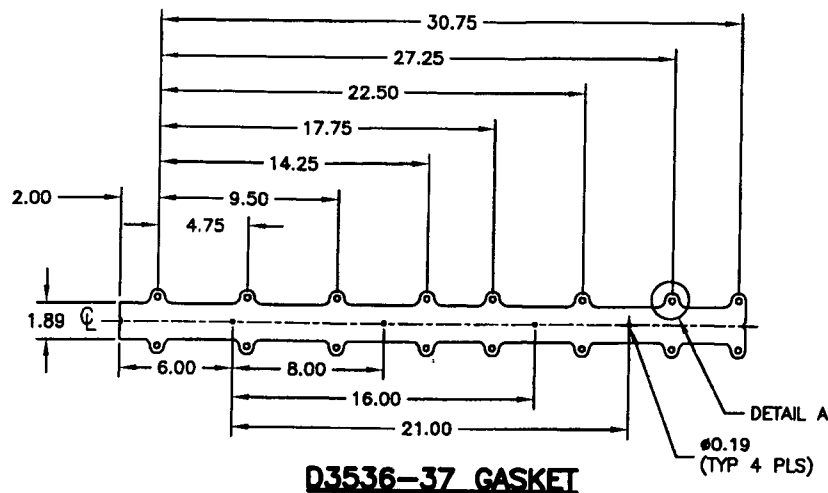
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CHECKED	PH	APPROVED		PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 5 OF 6
				SCALE 1:10



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CL
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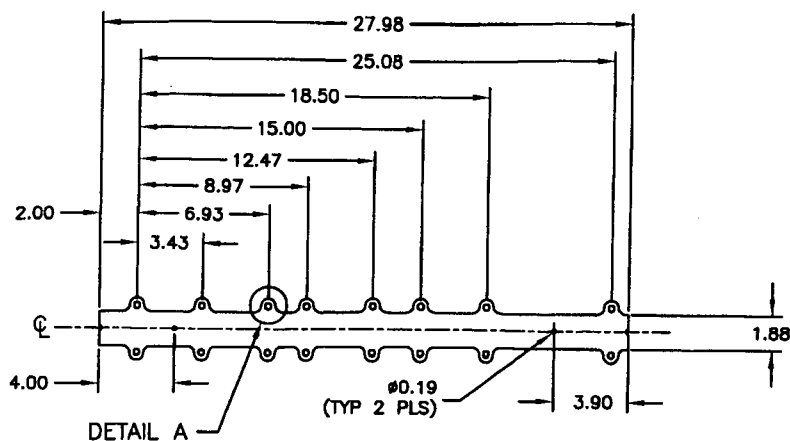
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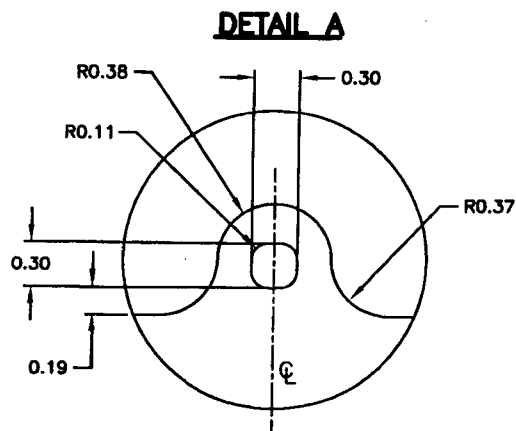


070212 CH

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 6 OF 6
		SCALE	1:10	



D3536-41 GASKET



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
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